

Work Order ID 122478

Tuesday, July 22, 2014 8:37:43 AM

122478

Page 1

Item ID: D4008-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spring
 Start Date: 7/21/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 7/21/14 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-07-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4008 | D |

100 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 25154
 Purchase Part Number: 206-031-140-001
 Supplier: BELL HELICOPTER
 Certificate of conformity is required

0.00

CL 14/07/24 20

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

14/07/17 (20)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
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Work Order ID 122478

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Revision ID: Stop ***NS2***
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|-------------------|---------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | DAS 16 9-89 | N/18/17 | | (20) | | | |
| Quality Control | | | | | | | | | |
| 130 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

14-08-11
MLJ
(H) 14-8-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
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| Unapproved | | | | | | | | | |

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|--|--|---|--|

Picklist Print

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Work Order ID: 122478

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Parent Item: D4008-9

D4008-9

Parent Item Name: Spring

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP rev A 09.12.23 new Issue Prelim EC verified by: DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07
AS PER DWG REV.C DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| 206-031-140-001 | | Purchased | | | | 110 | Each | 0.0000 | 1 | 20 | | | |
| *206-031-140-001* | | | | | | | | | | ** | | | |

Splash Guard

D4008-9P

X20

Pa 14/8/17 (20)



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25154

Purchase Order Date 7/24/2014

PO Print Date 7/24/2014

Page Number 1 of 2

Order From :

VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FILED

Contact Name

Vendor Phone 866 230 5312

Ship To Contact

Ship To Phone

Ship Via: FedEx PI ppd

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

| Line Nbr | Reference Vendor Part Number Line Comments Delivery Comments | Description/ Mfg ID | Req Date/ Taxable Promise Date | CD | Req Qty/ Unit of Measure | PO Unit Price | Extended Price |
|----------|--|------------------------|--------------------------------------|----|--------------------------------|---------------|----------------|
| 1 | D4008-9P | Spring | 8/6/2014 Yes 8/6/2014 | | 20.00 Each | \$7.44 | \$148.80 |

AS PER DWG D4008 REV. D
B122478

Line Total: \$148.80

| | | | | | | | |
|---|----------|--|----------------------------|--|------|--------|--------|
| 2 | 71401-45 | | 8/6/2014 No 8/6/2014 | | 1.00 | \$0.00 | \$0.00 |
|---|----------|--|----------------------------|--|------|--------|--------|

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER,
(DOCUMENTATION SENT TO DART AEROSPACE)
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.

Note:

7/24/2014



PACKING SLIP

30456

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

BILL TO:

Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A, 1K7

SHIP TO:

| DATE | | ORDER No. | | SHIP VIA | |
|-----------|-----------------|-----------|---------|----------|--------|
| 6-Aug-14 | | PO25154 | | | |
| QUANTITY | DESCRIPTION | | | UNIT | AMOUNT |
| 20 | D4008-9P Spring | | | | |
| GST # | TERMS | SUBTOTAL | FREIGHT | GST | TOTAL |
| 854454527 | NET 30 DAYS | | | | |

CERTIFICATE OF CONFORMANCE

| | |
|---------------------------------|----------------|
| REPORT FOR : Dart Aerospace Ltd | DATE: 8/6/2014 |
| PART/DRAWING #: D40089-P | PO # PO25154 |
| DESCR: Torsion Spring | QUANTITY: 20 |

| CHARACTERISTIC | SPECIFIED | MEASURED | NOTES |
|-------------------|-----------|----------|-------|
| Material type | SS302 | SS302 | |
| Material diameter | 0.035" | 0.035" | |
| Coil I.D. | | | |
| Coil O.D. "D" | 0.19" | 0.195" | |
| Width "W" | 0.46" | 0.456" | |
| Height "H" | 0.99" | 1.047" | |
| | | | |
| | | | |
| | | | |

COMMENTS

5/14/10/07

Mill Certificate attached: Yes
Material Heat Number: 41646

Inspected by: *Jeremy Burrows*

MATERIAL CERTIFICATION

| REPORT FOR: Dart Aerospace Ltd. | DATE: 8/6/2014 | | | | | | | | | | | | | | | | | | | | | | |
|---|------------------|-----------------|-----------------|-------------------|--------------|-----------------------|--|--------------------|------------------|-----------------------|--|------------------------|--|--------------------|--|---------------------|--------------|-----------------------|--|---------------------|--|--------------------|--|
| PART/DRAWING #: D4008-9P | PO # PO25154 | | | | | | | | | | | | | | | | | | | | | | |
| SPRING DESCRIPTION: Torsion | QUANTITY: 20 | | | | | | | | | | | | | | | | | | | | | | |
| MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03 | | | | | | | | | | | | | | | | | | | | | | | |
| <p>PROPERTIES:</p> <table> <thead> <tr> <th><u>Chemical</u></th> <th><u>Physical</u></th> </tr> </thead> <tbody> <tr> <td>Carbon: (C) 0.070</td> <td>Size: 0.035"</td> </tr> <tr> <td>Chromium: (Cr) 18.130</td> <td></td> </tr> <tr> <td>Copper: (Cu) 0.410</td> <td>Tensile: 298,000</td> </tr> <tr> <td>Manganese: (Mn) 1.400</td> <td></td> </tr> <tr> <td>Molybdenum: (Mo) 0.290</td> <td></td> </tr> <tr> <td>Nickel: (Ni) 8.040</td> <td></td> </tr> <tr> <td>Nitrogen: (N) 0.080</td> <td>Heat # 41646</td> </tr> <tr> <td>Phosphorus: (P) 0.032</td> <td></td> </tr> <tr> <td>Silicon: (Si) 0.330</td> <td></td> </tr> <tr> <td>Sulphur: (S) 0.001</td> <td></td> </tr> </tbody> </table> <p>Mill Source: Sumiden Origin Country: USA</p> | | <u>Chemical</u> | <u>Physical</u> | Carbon: (C) 0.070 | Size: 0.035" | Chromium: (Cr) 18.130 | | Copper: (Cu) 0.410 | Tensile: 298,000 | Manganese: (Mn) 1.400 | | Molybdenum: (Mo) 0.290 | | Nickel: (Ni) 8.040 | | Nitrogen: (N) 0.080 | Heat # 41646 | Phosphorus: (P) 0.032 | | Silicon: (Si) 0.330 | | Sulphur: (S) 0.001 | |
| <u>Chemical</u> | <u>Physical</u> | | | | | | | | | | | | | | | | | | | | | | |
| Carbon: (C) 0.070 | Size: 0.035" | | | | | | | | | | | | | | | | | | | | | | |
| Chromium: (Cr) 18.130 | | | | | | | | | | | | | | | | | | | | | | | |
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| Nitrogen: (N) 0.080 | Heat # 41646 | | | | | | | | | | | | | | | | | | | | | | |
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| Silicon: (Si) 0.330 | | | | | | | | | | | | | | | | | | | | | | | |
| Sulphur: (S) 0.001 | | | | | | | | | | | | | | | | | | | | | | | |

Certified by: Jeremy Burrows

Victory Spring Ltd. certifies this to be a true & accurate copy of the original
contained in the company records.